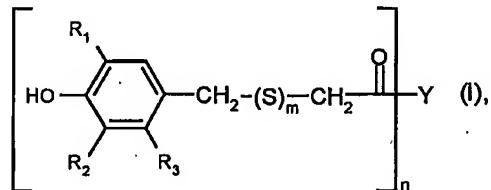
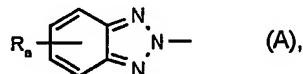


What is claimed is:

1. A method of producing low-dust granules of polymer additives or polymer additive mixtures, wherein the granule-forming polymer additives are mixed together, the mixture is converted into a workable mass and pressed through an orifice, and the pre-shaped strand-like extruded mass is cooled and, while still in a workable state, formed into granules by rolling, impressing, cooling and comminuting.
- 5 2. A method according to claim 1, wherein there are mixed together as granule-forming polymer additives phenolic polymer additives of formula:



10 wherein, independently of one another, one of  $\text{R}_1$  and  $\text{R}_2$  is hydrogen, a substituent selected from the group  $\text{C}_1\text{-C}_{18}\text{alkyl}$ , phenyl,  $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl}$ , phenyl- $\text{C}_1\text{-C}_3\text{alkyl}$ ,  $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl-C}_1\text{-C}_3\text{alkyl}$ ,  $\text{C}_5\text{-C}_{12}\text{cycloalkyl}$  and  $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{C}_5\text{-C}_{12}\text{cycloalkyl}$  or a group of partial formula



15 wherein  $\text{R}_a$  is hydrogen or a substituent selected from the group  $\text{C}_1\text{-C}_4\text{alkyl}$ , halogen and sulfo;

and the other is a substituent selected from the group  $\text{C}_1\text{-C}_{18}\text{alkyl}$ , phenyl,  $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl}$ , phenyl- $\text{C}_1\text{-C}_3\text{alkyl}$ ,  $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{phenyl-C}_1\text{-C}_3\text{alkyl}$ ,  $\text{C}_5\text{-C}_{12}\text{cycloalkyl}$  and  $(\text{C}_1\text{-C}_4\text{alkyl})_{1\text{-}3}\text{C}_5\text{-C}_{12}\text{cycloalkyl}$  or a group of partial formula (A)

20 wherein  $\text{R}_a$  is as defined;

$\text{R}_3$  is hydrogen or methyl;

$m$  is the number zero or 1; and

$n$  is an integer from 1 to 4; wherein,

when  $n$  is the number 1,

25  $m$  is zero or 1 and  $\text{Y}$  denotes

a monovalent substituent  $-O-Y_1$  or  $-N(-Y_2)_2$ , wherein

$Y_1$  is  $C_5-C_{45}$ alkyl,  $C_3-C_{45}$ alkyl interrupted by at least one oxygen atom,  $C_5-C_{12}$ cycloalkyl,  $C_2-C_{12}$ alkenyl,

a substituent of partial formula

5  $-CH_2-CH(OH)-CH_2-O-C(=O)-R_b$ , (B),

wherein  $R_b$  is hydrogen,  $C_1-C_6$ alkyl,  $C_3-C_5$ alkenyl or benzyl,

a substituent of partial formula

$-CH_2-CH_2-O-R_c$  (C),

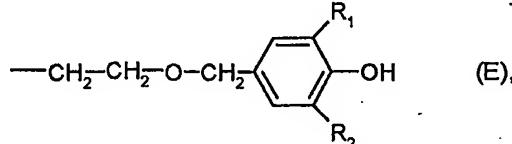
wherein  $R_c$  is hydrogen,  $C_1-C_{24}$ alkyl,  $C_5-C_{12}$ cycloalkyl or phenyl,

10 a substituent of partial formula

$-CH_2-CH_2-O-CHR_d-CHR_e-C(=O)-O-R_f$  (D),

wherein one of  $R_d$  and  $R_e$  is hydrogen or methyl and the other is methyl, and  $R_f$  is hydrogen or  $C_1-C_{24}$ alkyl,

a substituent of partial formula



15

wherein  $R_1$  and  $R_2$  are as defined above,

or a substituent of partial formula

$-CH_2-CH_2-O-CH_2-C(=O)-O-R_g$  (F),

wherein  $R_g$  is hydrogen or  $C_1-C_{24}$ alkyl; and

20  $Y_2$  is hydroxy- $C_2-C_4$ alkyl; or,

when  $n$  is the number 2,

$m$  is zero and  $Y$  is a bivalent group of partial formula

$-O-C_xH_{2x}-O-$  (G),

wherein  $x$  is an integer from 2 to 20,

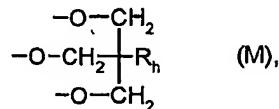
25  $-O-(CH_2-CH_2-O)_yCH_2-CH_2-O-$  (H),

wherein  $y$  is an integer from 1 to 30,

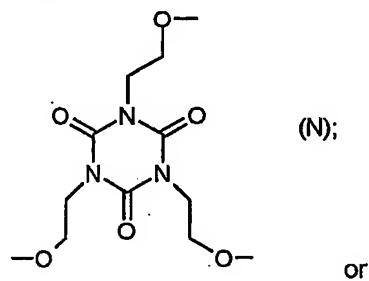
$\text{-O-CH}_2\text{-CH}_2\text{-S-CH}_2\text{-CH}_2\text{-O-}$  (I),  
 $\text{-O-CH}_2\text{-CH=CH-CH}_2\text{-O-}$  (K) or  
 $\text{-NH-}(\text{CH}_2)_z\text{-NH-}$  (L),

wherein z is zero or an integer from two to ten; or,

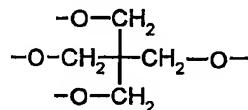
5 when n is the number 3, m is zero and Y is a trivalent group of partial formula



wherein  $R_h$  is  $C_1$ - $C_{24}$ alkyl or phenyl, or

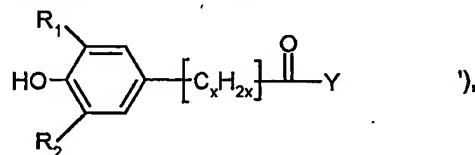


when  $n$  is the number 4,  $m$  is zero and  $Y$  is the tetravalent group of partial formula

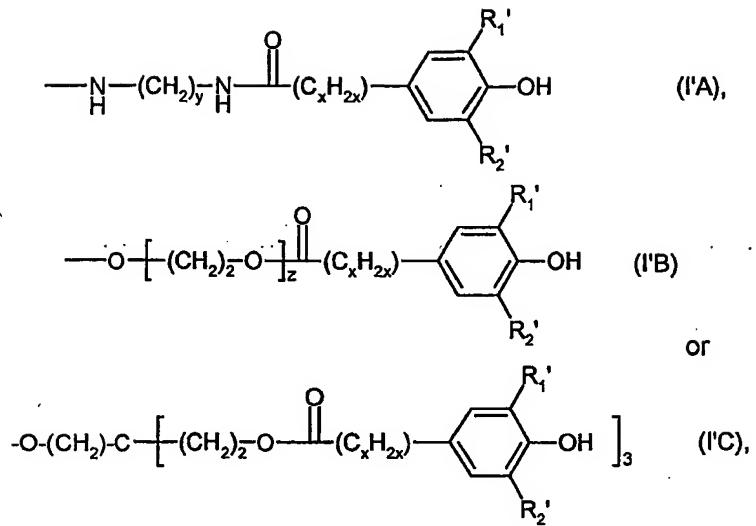


10

3. A method according to claim 1, wherein there are mixed together as granule-forming polymer additives phenolic polymer additives of formula:



wherein, independently of one another, one of  $R_1$  and  $R_2$  is hydrogen or  $C_1$ - $C_4$ alkyl and the other is  $C_3$ - $C_4$ alkyl;  $x$  is zero (direct bond) or an integer from one to three; and  $Y$  is  $C_8$ - $C_{22}$ alkoxy or a group of partial formula



wherein, independently of one another, one of R<sub>1</sub>' and R<sub>2</sub>' is hydrogen or C<sub>1</sub>-C<sub>4</sub>alkyl and the other is C<sub>3</sub>-C<sub>4</sub>alkyl; x is zero (direct bond) or an integer from one to three; y is an integer from two to ten and z is an integer from two to six.

5. 4. A method according to claim 1, wherein the mixture of granule-forming polymer additives is converted into a workable mass in a heatable ko-kneader.
10. 5. A method according to claim 1, wherein the workable mass is extruded from the ko-kneader through a circular nozzle or slot-shaped nozzle and the pre-shaped, strand-like mass is subjected to further processing.
15. 6. A method according to claim 1, wherein the plastic, pre-shaped mass is processed by squeeze rollers having a smooth and polished surface and then shaping rollers provided with embossing lines.
7. 7. A method according to claim 1, wherein the shaping rollers are provided with grooves.
8. 8. A method according to claim 1, wherein the transport and the cooling and solidification are carried out on a continuous steel belt.
9. 9. A method according to claim 1, wherein the components of the granule-forming polymer additives are fed into the ko-kneader in liquid or solid form or in molten form.
20. 10. A method according to claim 1, wherein the impressed product mat is comminuted to granule size in a sieve granulator.